

ASAP 11

# Work Order ID 60105

June 24, 2010 11:38:43 AM



Item ID: D2565-111

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 6/24/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/25/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2565

Rev E

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Punch as per Dwg D2565 using DT 8313

SB 6/24/10

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr and polish

SB 6/24/10

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

SB 6/24/10

*[Signature]*

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Start Date: 6/24/10 Start Qty: 1.00



Cust Item ID:

Required Date: 6/25/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

M114841

Memo

0.00

Powder Coating

START TIME:

2:25

OVEN TEMPERATURE:

FINISH TIME:

2:55

①

BL 10-6-24.

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Pick/po

150

Identify as per dwg & Stock Location:

270

0.00



Packaging

Memo

0.00

Packaging

P.O. 14/20 ①

**Work Order ID 60105**

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Item ID: D2565-111

Accept

Setup Start

Revision ID:

Stop

Item Name: Strut

Start Date: 6/24/10 Start Qty: 1.00

Cust Item ID:

Required Date: 6/25/10 Req'd Qty: 1.00

Customer:

Reference:

Run Start

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/6/25**CL10/6/25*

# Picklist Print

June 24, 2010 11:38:42 AM

Page 1

Work Order ID: 60105

Parent Item: D2565-111

Parent Item Name: Strut



Start Date: 6/24/10

Required Date: 6/25/10

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP: E101.06.04 Added Powder Coat, Removed Polish, and Added Inspection Levels 3 & 2111 EC  
IPP: E106.05.03 Change level 2/8 to QC5 ECH11

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	389.7568	1.1375	1.197368			



304 RD Tube .750 x .049W

Location	Loc Qty	Loc Code
MAT	361.89334	
108498	0	
110113	0	
114482	6.6065	
114852	137.28684	
115010	218	
MAT017	27.8635	
109314	9.33	
110113	5.29	
112800	13.2435	

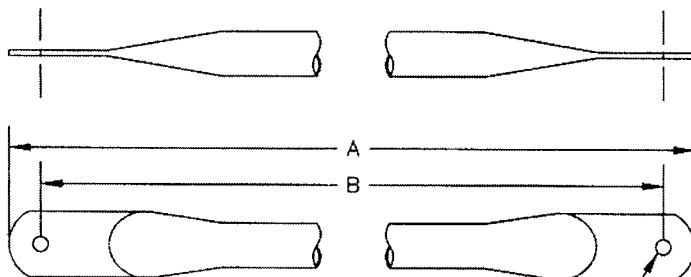
2.2 SB 6/24/24 ①



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED  
04.05.05 *[Signature]*

*who*  
*notes*



DIA 0.257 TO BE PUNCHED  
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

#### GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
(REF DART SPEC. M304TR0.750W0.049)  
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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